

Work Order ID 116702

April-24-14 8:56:49 AM

Black
116702 LH

Page 1

Item ID: D205-634-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/09/14

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: MLS

Date: 14-04-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D205-634

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D205-634 bluefile & type labels per PPP D205-634-145 CHG001

N/A MLS 14-08-20

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- PICK D2580-1

2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021,
DRILL 3.630" HOLES USING DT8462 (83.94" FROM AFT OF D2580-1 REF.
ONLY)

14-5-20 DL/DGL

Work Order ID 116702

April-24-14 8:56:49 AM

116702

Page 2

Item ID: D205-634-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/09/14

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT 16

2-Cut tubes as per Dwg. D2580

3- Scribe batch# in aft end of tube

> 14-5-20 JH/DGL

130

0.00

130

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required.

2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7.

3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7.

4-Drill pilot holes for aft cap using DT8215, Open to finished size.

DGL 14-5-21

Work Order ID 116702

April-24-14 8:56:50 AM

116702

Page 3

Item ID: D205-634-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/09/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DAS
18
9-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

1 0 14-05-21

150

0.00

150

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and OSI 004
A/R Aluminum Rod *m127763*

2-Touch up alodine on run on wearplate holes prior to swaging
3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg

4-DRILL TOWING HOLE USING DT8091

5-DEBURR

14-05-21
14-5-22
14-5-26

Work Order ID 116702

April-24-14 8:56:50 AM

116702

Page 4

Item ID: D205-634-145

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/09/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC10- Inspect visual per QSI004- ground welds	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Pressure Wash per QSI005 4.3	0.00							
180									
HandFinish	Memo	0.00							
Hand Finishing	And realodine tube as per QSI 005								

1 76 146-4

April-24-14 8:56:50 AM

Item ID: D205-634-145

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Stop *NS2*

Start Date: 4/23/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 5/09/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

~~190~~ 190

~~White Gloss(Ref:4.3.5.1)~~ per QSI005 4.3-Alum

0.00

190

Memo

0.00

Powdercoat

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

Work Order ID 116702

April-24-14 8:56:50 AM

116702 LH

Page 6

Item ID: D205-634-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/09/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Assemble as per dwg
HandFinishing

0.00

210

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on
insert holes before installing wearplates

A/R Sikaflex-291 111728979

Sikaflex expire date: 15/01

RTU 598 11125792 exp 12/09

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594

3- Install aft cap as per dwg

4- Wing walk as per dwg Batch# 14129693

x 1/16 H 1/16 H 1/16 H 14/08/06

220

QC5- Inspect part completeness to step on W/O

0.00

220

QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for
Foreign objects per QSI 024

1 5 14/08/20 DAS 38 9-89 14/08/20

Work Order ID 116702

April-24-14 8:56:50 AM

116702

Page 7

Item ID: D205-634-145

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/09/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Packaging	0.00							
230									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-145								
	Location: _____								
	PPP Rev: _____								
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

AUG 20 2014

DAS
06
8-89

MLJ 14-08-21

MLJ 14-08-20

Picklist Print

April-24-14 8:56:48 AM

Page 1

Work Order ID: 116702

116702

Parent Item: D205-634-145

D205-634-145

Parent Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14

Required Date: 5/09/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.04.23 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2580-1		Manufactured	No				Each	4.0000		1			
---------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

D2580-1
205 Bent Tube

Location	Loc Qty	Loc Code
LG	4	
114783	1	
115862	3	

① 14-5-20/4/DOL

D2596		Manufactured	No				Each	10.0000		1			
-------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

D2596
Web, 205 Skidtube

Location	Loc Qty	Loc Code
LG002	10	
109898	4	
115023	6	

part is in D2580-1

D4202-1		Manufactured	No				Each	434.0000		24			
---------	--	--------------	----	--	--	--	------	----------	--	----	--	--	--

D4202-1
Spacer

Location	Loc Qty	Loc Code
LG	367	
113770	367	
LG001	67	
105931	67	

② 24 DOL 14-5-26.

Picklist Print

April-24-14 8:56:48 AM

Page 2

Work Order ID: 116702

116702

Parent Item: D205-634-145

D205-634-145

Parent Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14

Required Date: 5/09/14

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

Each

332.0000

8

D2594-1

Plug

del 11/08/05

Location

Loc Qty

Loc Code

FP001

315

B119830

110311

175

x 8

112516

60

112727

80

FP002

17

106252

17

D2576-3

Manufactured No

Each

67.0000

1

D2576-3

Step (Machining Detail)

del 14-05-21

Location

Loc Qty

Loc Code

LG

50

112978

50

LG001

17

105581

17

D2594-3

Manufactured No

Each

789.0000

8

D2594-3

O-Ring

del 11/08/05

Location

Loc Qty

Loc Code

FP001

789

108402

188

110671

98

112234

3

113590

500

x 8

April-24-14 8:56:49 AM

Shop Packet Print

Page 2

Picklist Print

April-24-14 8:56:49 AM

Page 3

Work Order ID: 116702

116702

Parent Item: D205-634-145

D205-634-145

Parent Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14

Required Date: 5/09/14

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

Each

58.0000

1

D2855

Cap

see also doc

Location

Loc Qty

Loc Code

FP001

56

B117281

105248

6

x1

111897

50

ST019

2

10360

2

AN3-5A

Purchased

No

Each

1,003.000

2

AN3-5A

Bolt

see also doc

Location

Loc Qty

Loc Code

GA

49

117423

49

ST511

836

m126559

836

ST512

118

124561

118

x2

NAS1149D0332J

Purchased

No

Each

5,638.000

2

NAS1149D0332.J

Washer

see also doc

Location

Loc Qty

Loc Code

ST294

638

m128606

638

x2

ST510a

5000

m128612

5000

Picklist Print

April-24-14 8:56:49 AM

Page 4

Work Order ID: 116702

116702

Parent Item: D205-634-145

D205-634-145

Parent Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14

Required Date: 5/09/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225 AELS8-1032-225 Purchased No

Each 1,195.000

2

ALS4-1032-225

Rivnut

W/D

W/D

Location

Loc Qty

Loc Code

FG	30	
M127028	30	
FP001	848	
M128649	848	
ST280	291	
M127028	10	
M128179	281	
st555	26	
M127092	26	

D5061-1 Manufactured No

Each 0.0000

1

D5061-1

Fwd Wearplate

B117596 (1/1) all w/d 8/06

D5061-3 Manufactured No

Each 2.0000

1

D5061-3

Aft Wearplate

B117597 (1/1) all w/d 8/06/19

Location

Loc Qty

Loc Code

prelim	2	
113413	2	

AN4-45A Purchased No

Each 51.0000

8

AN4-45A

BOLT

all w/d 8/06

Location

Loc Qty

Loc Code

ST517	51	
m126176	4	
m126333	38	
m128403	9	

M129612

x 2

April-24-14 8:56:49 AM

Shop Packet Print

Page 4

Picklist Print

April-24-14 8:56:49 AM

Page 5

Work Order ID: 116702

116702

Parent Item: D205-634-145

D205-634-145

Parent Item Name: Replacement Skidtube with Thru-Bolt Wearplates

Start Date: 4/23/14

Required Date: 5/09/14

Start Qty: 1.00

Required Qty: 1.00

D2570

Manufactured No

Each

341.0000

16

D2570

Bushing

**

all 4/28/14

Location

Loc Qty

Loc Code

FG

12

88781

12

B120285

VL6

ST011

329

108538

196

110735

80

112726

5

113679

48

Each

24.0000

8

**

all 4/28/14

MS21042-4

MS21042L4

Purchased

No

MS21042-4

Nut

Location

Loc Qty

Loc Code

ST314

24

m2937

12

m8182

12

K1124231

28

April-24-14 8:56:49 AM

Shop Packet Print

Page 5